



Date: Tuesday, 6/27/2006 1:37:56 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 27649

Part Number: D33031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06.07.10

7

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-07-20

7

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

AL 06/07/21

7

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST422

AL 06/07/21

7

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/31

7

Job Completion



06.07.31

→

Date: Monday, 6/19/2006 11:30:58 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 27649		
Estimate Number	: 10424		
P.O. Number	:	Part Number	: D33031
This Issue	: 6/19/2006 S.O. No. :	Drawing Number	: D3303 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26691	Material	:
Written By	: <u>                    </u>	Due Date	: 7/10/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>                    </u>		
Comment	: Est:A 04.09.07 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.3719 sf(s)/Unit Total: 3.7191 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.032" thick  
 (M2024T3S.032) Batch: \_\_\_\_\_

SHEAR



SHEAR



Comment: SHEAR

Cut blank: 9.200" x 5.050"

*Water Jet  
Dry Rev  
Dry Rev.*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: ~~HAAS CNC VERTICAL MACHINING #1~~  
 Machine as per Folio FA460 and Dwg D3303  
 Identify as D3303-1

*N/A*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



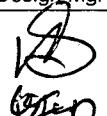
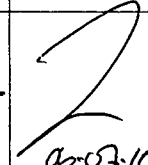
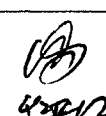
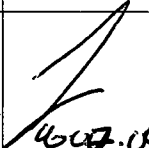
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-01	2	3 parts holes are over sized up to .148, due to water Jet.		Scrap: destroy.	SAD 06-07-08	 06-07-10	 06-07-12	 06-07-01

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:30:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 27649

Part Number: D33031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	27649
Description: Plate		Part Number:	D3303-1
Inspection Dwg: D3303	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

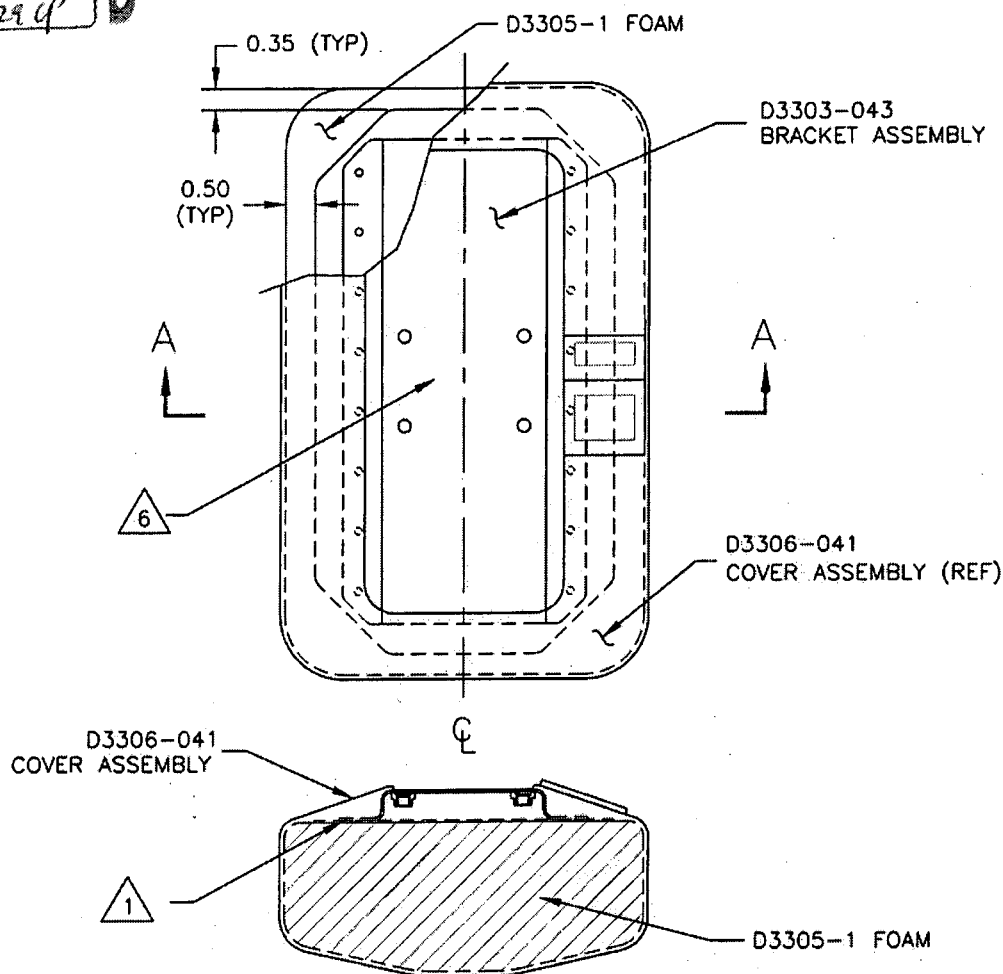
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.000	+/-0.010	5.002	✓		Vern	
3.550	+/-0.005	3.545	✓		Vern	
1.22 x 45°	+/-0.030	<del>6.994</del>	✓		<del>Vern</del>	
R0.25	+/-0.030	R0.25	✓		R-G	
9.10	+/-0.030	9.104	✓		Vern	
7.000	+/-0.005	6.994	✓		Vern	
1.000	+/-0.005	0.998	✓		Vern	
1.050	+/-0.010	1.045	✓		Vertical Vern	
0.725	+/-0.010	0.720	✓		Vern	
0.032	+/-0.010	0.032	✓		Vern	
1.22 x 45°	+/-0.030	1.20 x 45°	✓		Vern	

Measured by:	JAN	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	06.06.30	Date:	06.07.04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	[Signature]

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

**RELEASED**  
04.09.29 *UP***SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART-AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT  
ELIGIBILITY SEE PDA04-11"

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NO. 27649

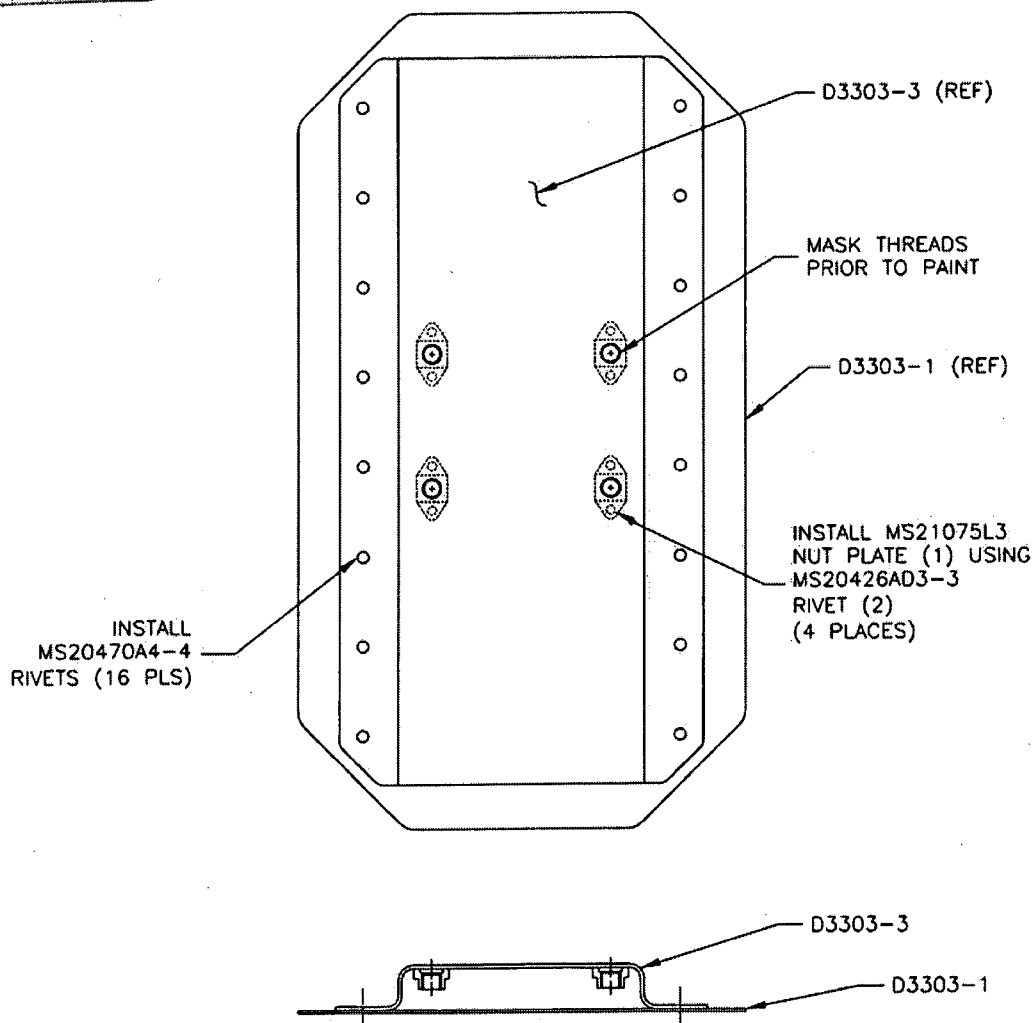
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

**RELEASED**  
04.09.19 [Signature]**D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

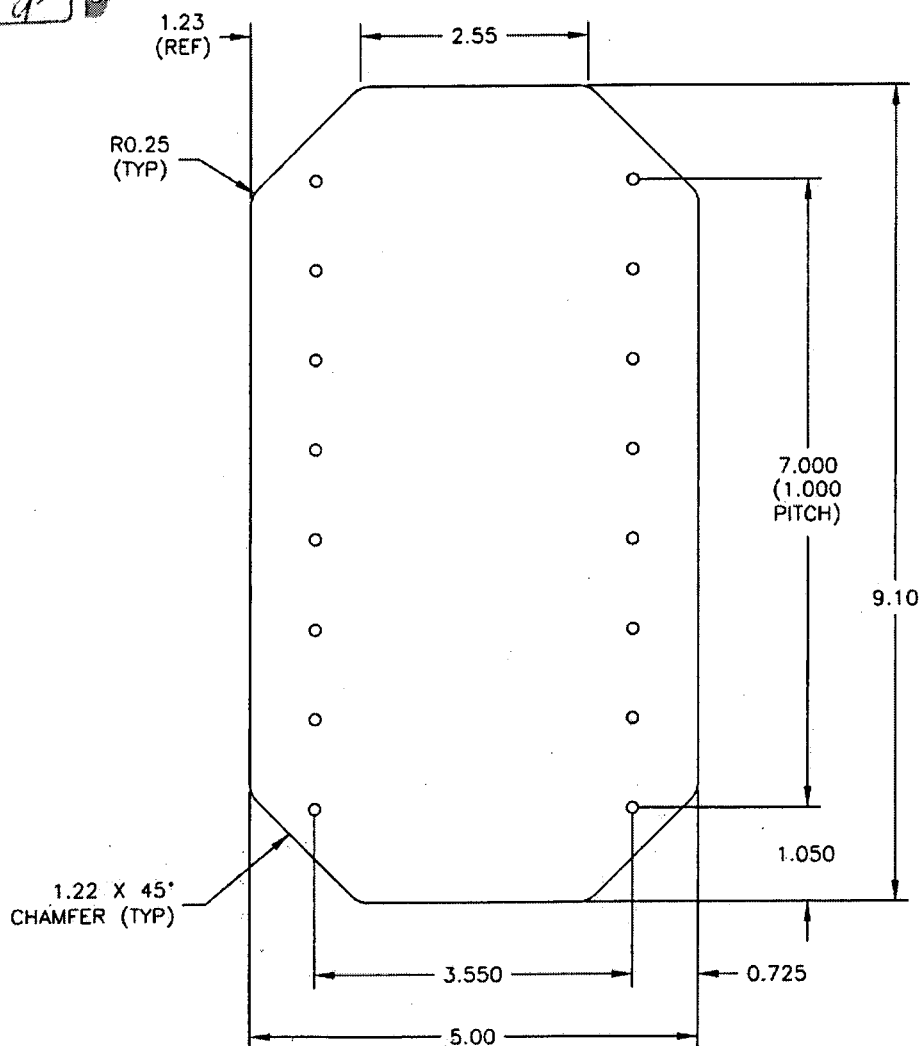
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**RELEASED**  
64.09.29 LP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T325.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

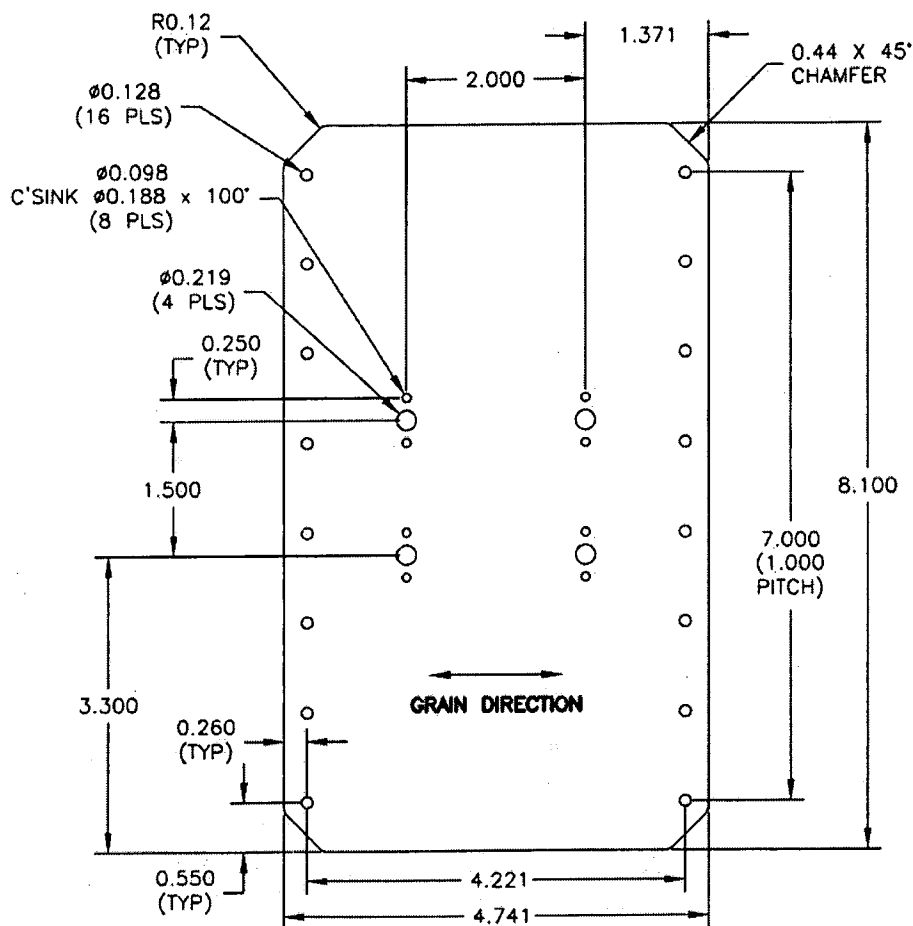
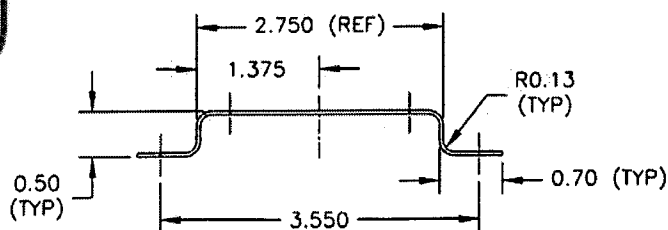
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CHECKED H	APPROVED H	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**  
04.09.29 UP**D3303-3 BRACKET  
BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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